

Work Order ID 65480

January 18, 2011 11:08:20 AM



Page 1

Item ID: D205-634-041

Accept



Setup Start



Revision ID:

Stop



Item Name: Replacement Skidtube

Start Date: 1/18/11 Start Qty: 1.00



Cust Item ID:

Required Date: 2/03/11 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan: CL

Date: 1/10/11

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

D2580

Rev.D DEO-D1

100

0.00



DOCUMENT CONTROL

DC

Memo

0.00

Document Control

Photocopy D205-634 bluefile & type labels per PPP D205-634-041 CHG003

8/11/02/16

OK for CL 11/02/15

110

0.00



BENDING MACHINE - SKIDTUBES

CNC Bend 1

Memo

0.00

CNC Delta 100 Bender

1-Bend as per program D2580.C on CNC Bender and Folio 16

2-Cut tubes as per Dwg. D2580

3- scribe batch# in aft end of tube

DP

11-1-19

1365480

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120 		0.00							
Skidtubes	Memo	0.00							
Skidtubes	1- Deburr ends and remove bending marks								
	2- Prepare tube for swaging as per QSI 002								
130 	QC5- Inspect part completeness to step on W/O	0.00							
QC	Memo	0.00							
Quality Control									

B 11/01/19

BE 11/01/19

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Run Start

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

140

0.00



Skidtubes

Skidtubes

Memo

0.00

1-Weld step D2576 as per Dwg. D2580 and QSI004
A/R□□□ Aluminum Rod

2-Grind welds on step as per Dwg D2580

3-Insert D4202-1 spacer, swage as per QSI002 and trim/ grind flush per QSI002
and dwg. Hold x-bolt with DT9701 Use tube expander 1/2 x 17G to start
expansion and finish with 1/2 x 18G to achieve dwg dimension.4-Drill holes for wearplates using DT 8217 & DT8937 Open holes to 19/64",
adjust stopper not to hit web. Deburr

6-Drill pilot holes for aft cap using DT 8215 Open holes to 0.208". Deburr

7-Drill pilot holes for Tow ring using DT8091, open to .640" and Deburr

150



QC

Quality Control

QC10- Inspect visual per QSI004- ground welds

0.00

Memo

0.00

Sulco 1/18/11

11-2-7

BB

11/02/08

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

160

QC5- Inspect part completeness to step on W/O

0.00

8/16/08

QC

Memo

0.00



Quality Control

170

Pressure Wash per QSI005 4.3

0.00

Hand Finish

Memo

0.00

Hand Finishing

Re-alodine tube as per QSI 005 section 4.1.2.1 do not acid etch and leave fwd cap out of solution.

See note pg.

180

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00

Powdercoat

Memo

0.00

Powder Coating

START TIME: _____
OVEN TEMPERATURE: _____
FINISH TIME: _____

Handwritten signatures and notes

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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NOTE: Date & initial all entries

Work Order ID 65480

Wednesday, February 09, 2011 9:12:06 AM

Page 4

Item ID: D205-634-041

Accept

Revision ID:

Item Name: Replacement Skidtube

Start Date: 1/18/2011 Start Qty: 1.00

Required Date: 2/3/2011 Req'd Qty: 1.00

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID Tool # Plan Accept Reject Reject Insp.
Code Qty Qty Number Stamp

160

QC5- Inspect part completeness to step on W/O

0.00

ML 11 02 08 ⑦



QC

Memo

0.00

Quality Control

170

Pressure Wash per QSI005 4.3

0.00



HandFinish

Memo

0.00

Hand Finishing

Re-alodine tube as per QSI 005 section 4.1.2.1 do not acid etch and leave fwd cap out of solution.

1 ① ML 11/02/10

180

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00



Powdercoat

Memo

0.00

Powder Coating

START TIME:
OVEN TEMPERATURE:
FINISH TIME:

1:45
300°
2:15
2:45
300°
3:15

1 BLK 11-2-10

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Item ID: D205-634-041

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Cust Item ID:

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Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

190

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

1 0 40 1/102/11

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Wednesday, February 09, 2011 9:12:06 AM

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Start Date: 1/18/2011 Start Qty: 1.00

Required Date: 2/3/2011 Req'd Qty: 1.00

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

200

0.00



HandFinish

Hand Finishing

Memo

0.00

1-Install inserts & wearplates & Gaskets as per Dwg. D2580. Use a drop of Sikaflex on insert holes before installing wearplates

A/R Sikaflex-291 M115114

Sikaflex expire date: 11/02

2-Coat D2594-3 O' rings with Petroleum Jelly and install on D2594-1 plugs as per Dwg D2580

3-Inspect for foreign object per QSI 024

4-Install 2855 Aft Cap as per Dwg D2580 and seal Fwd Step & Aft Cap with Sikaflex. Clean excess adhesive

A/R Sikaflex-291 M115114

Sikaflex expire date: 11/02

5-Wing Walk as per Dwg D2580 and QSI 005 4.4

Batch: M1116402



Cust Item ID:

Customer:

Setup Start

Stop



1: 0 22 11/02/11

Work Order ID 65480

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Item ID: D205-634-041

Accept

Setup Start

Revision ID:

Stop

Item Name: Replacement Skidtube

Start Date: 1/18/11 Start Qty: 1.00

Cust Item ID:

Required Date: 2/03/11 Req'd Qty: 1.00

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

210

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

Inspect Aft Cap, Fwd Step and Wing Walk of work to Current Step Inspect for Foreign objects per QSI 024

220

Packaging

0.00



Packaging

Memo

0.00

Packaging

Identify and pack for shipping as per PPPD205-634-041

Location: _____

PPP Rev: _____

230

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control



Cup/2/16 (1)

11/02/16

11-02-16

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Page 1

[REDACTED]

Abstract

Start Date: 1/18/11**Required Date:** 2/03/11

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:N 02.08.28 FP was QC5 in Step 27; Added QC5 to Step 30
KJ IPP Rev P 10.02.19
per PAR09-043 EC verified by:DD
IPP Rev. O 06.02.28 Added paperwork EC
IPP Rev:P 07-07-09 SS Wearplates & Gaskets JLM IPP Rev:Q
10.12.01 as per chg003 DD verf:EC

Part Number	Barcode	Manufacturer	Quantity	Unit	Price	Location	Loc Qty	Loc Code	Notes
D4202-1	[Barcode]	Manufactured	140	Each	106.0000	LG	106		BE 11/02/03
Spacer	[Barcode]					64608	106		B 65529 (x14)
D2580-1	[Barcode]	Manufactured	110	Each	7.0000	LG	4		
205 Skidtube bent detail	[Barcode]					63050	2		
						63051	2		
						ST046	3		
						59856	1		
						46601	2		
D2576-3	[Barcode]	Manufactured	140	Each	63.0000	LG	63		
Step (maching detail)	[Barcode]					46661	15		
						52215	48		

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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Picklist Print

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Page 2

Work Order ID: 65480

Parent Item: D205-634-041

Parent Item Name: Replacement Skidtube

Start Date: 1/18/11

Required Date: 2/03/11

Start Qty: 1.00

Required Qty: 1.00

D2855 Manufactured No 200 Each 54.0000 1



Cap



11/02/11

Location Loc Qty Loc Code

FP6 3
56613 1
63634 2
ST026 51
50513 1
50770 28
51539 2
53791 20

AN3-5A Purchased No 200 Each 885.0000 2



Bolt



11/02/11

Location Loc Qty Loc Code

ST350 885
115016 385
115371 500

AN960JD10L NAS1149D0332J Purchased No 200 Each 0.0000 2



Washer

M1164H1



(x2) 11/02/11

ALS7-1032-130 Purchased No 200 Each 1,628.000 50



11/02/11

Insert

Location Loc Qty Loc Code

FP 689
115079 689
ST282 939
113238 17
115502 500
115581 422

M114723

11/02/11

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Page 2

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Work Order ID: 65480

Parent Item: D205-634-041

Parent Item Name: Replacement Skidtube

Start Date: 1/18/11

Required Date: 2/03/11

Start Qty: 1.00

Required Qty: 1.00

AN3C4A Purchased No 200 Each 1,230.000 50 50



BOLT

Location

Loc Qty

Loc Code

ST350

1230

115300

25

115936

8

116075

997

116590

200

yl 110211

AN960C10L NAS1149C0332 Purchased No 200 Each 25.0000 50 50

R



washer

Location

Loc Qty

Loc Code

ST245

25

107534

25

1116025

x50

D3566-13 Manufactured No 200 Each 26.0000 1 1



Gasket

Location

Loc Qty

Loc Code

FP012

6

61996

6

FP014

20

64070

20

x1

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Page 3

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Page 4

Work Order ID: 65480

Parent Item: D205-634-041

Parent Item Name: Replacement Skidtube

Start Date: 1/18/11

Required Date: 2/03/11

Start Qty: 1.00

Required Qty: 1.00

D3566-5

Manufactured No

200

Each

13.0000

1

1



Gasket

Location

Loc Qty

Loc Code

FP

12

B66146

64789

12

FP015

1

63574

1

D3566-1

Manufactured No

200

Each

6.0000

2

2



Gasket

Location

Loc Qty

Loc Code

FP015

6

B65988

57715

1

63573

5

D3564-11

Manufactured No

200

Each

8.0000

1

1



Wearshoe

Location

Loc Qty

Loc Code

FP019

8

62236

8

D3564-13

Manufactured No

200

Each

16.0000

1

1



Wearshoe

Location

Loc Qty

Loc Code

FP17

16

59660

1

61828

3

62229

12

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Parent Item Name: Replacement Skidtube

Start Date: 1/18/11

Required Date: 2/03/11

Start Qty: 1.00

Required Qty: 1.00

D3564-9

Manufactured No

200

Each

17.0000

1

1



Wearshoe

Location

Loc Qty

Loc Code

FP

1

55334

1

FP019

1

61709

1

FP19

15

62238

15

D3564-5

Manufactured No

200

Each

22.0000

1

1



Wearshoe

Location

Loc Qty

Loc Code

FG

1

34806

1

FP19

2

57525

1

58709

1

FP-19

19

63575

8

65058

11

D2594-3

Manufactured No

200

Each

739.0000

16

16



O-Ring, 205 Skidtube

Location

Loc Qty

Loc Code

FP

43

55546

19

58191

12

59358

12

fpa

696

61762

696

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Parent Item Name: Replacement Skidtube

Start Date: 1/18/11

Required Date: 2/03/11

Start Qty: 1.00

Required Qty: 1.00

D2594-1

Manufactured No

200

Each

235.0000

16

16



Plug, 205 Skidtube



251 410211

Location

Loc Qty

Loc Code

FP

183

B65980

X16

42807

112

55002

71

FP14

52

58434

15

62893

37

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DART

DESIGN #	DRAWN BY RH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED #	APPROVED #	DRAWING NO. D2580	REV. 0 SHEET 1 OF 3
DATE 07.02.27		TITLE 205 SKIDTUBE ASSEMBLY	SCALE NTS
A	96.09.16	NEW ISSUE	
B	96.12.02	AS MANUFACTURED	
C	98.08.26	REDRAWN, INCLUDED DEO 9094/9097	
D	07.02.27	CHANGE TO SS WEARPLATES AND GASKETS, INCLUDE DEO 9124/9183	

RELEASED
07.06.28 #**DEO ATTACHED**

QTY -041	QTY -045	Part Number	Description
X		D2580-041	SKIDTUBE ASSEMBLY
	X	D2580-045	SKIDTUBE ASSEMBLY
1	1	D2500-1-190	EXTRUSION
1	1	D2576-3	STEP
20	24	D2579	CROSS BOLT SPACER
16	16	D2594-1	PLUG
16	16	D2594-3	O-RING
1	1	D2596	205 WEB
1	1	D2855	AFT CAP
1	1	D3564-5	WEARSHOE
1	1	D3564-9	WEARSHOE
1	1	D3564-11	WEARSHOE
1	1	D3564-13	WEARSHOE
2	2	D3566-1	GASKET
1	1	D3566-5	GASKET
1	1	D3566-13	GASKET
50	50	ALS7-1032-130 or AKS7-1032-130 or AKS4-1032-130 or AELS-1032-130	INSERT
50	50	AN3C4A	BOLT
2	2	AN3-5A	BOLT
50	50	AN960C10L	WASHER
2	2	AN960JD10L	WASHER

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 65480
02/11/91/18

GENERAL NOTES:

- 1) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 2) ALL DIMENSIONS ARE IN INCHES
- 3) INSERT D2596 WEB TO LOCATION SHOWN OFF AFT END OF SKIDTUBE AND BOND WEB INTO OUTER TUBE WITH NON-STRUCTURAL SIKAFLEX-241 ADHESIVE PER DART QSI 015 BEFORE BENDING. ENSURE HOLES LINE-UP.
- 4) BEND AS A SMOOTH RADIUS STARTING WITH A MAXIMUM CENTERLINE RADIUS OF 60 AND ENDING WITH A MINIMUM RADIUS OF 30. A MAXIMUM REDUCTION OF 0.200 IN DIAMETER IS ALLOWABLE IN THE BENT PORTION OF THE TUBE.
- 5) USE DART DRILL TEMPLATE TD2577-205 TO LOCATE AND DRILL Ø.297 HOLES FOR WEARSHOE INSERTS. INSTALL ALS7-1032-130 PER SECTION D-D (50 PLACES) AFTER FINISH. INSTALL AN3C4A BOLTS AND AN960C10L WASHERS WITH SIKAFLEX-241/-291.
- 6) WELDING TO BE DONE PER DART QSI 004.
- 7) FINISH:
SEE NOTES ON
PAGE 2 FOR D2580-041 AND
PAGE 3 FOR D2580-045
- 8) INSERT D2594-1 PLUG C/W D2594-3 O-RING IN HOLES MARKED 'P' (BOTH SIDES OF TUBE) AFTER FINISH (16 PLACES).

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

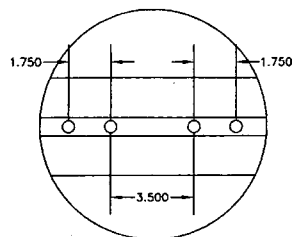
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

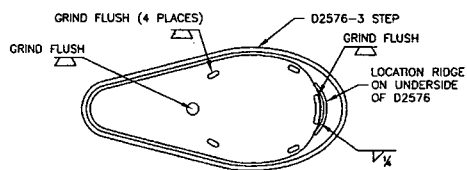
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

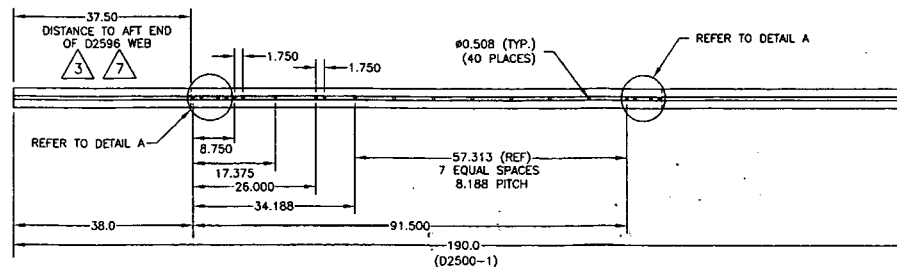
DETAIL A
SCALE 5:24



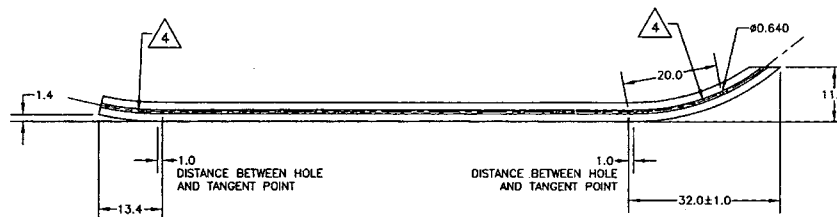
DETAIL B
SCALE 5:24



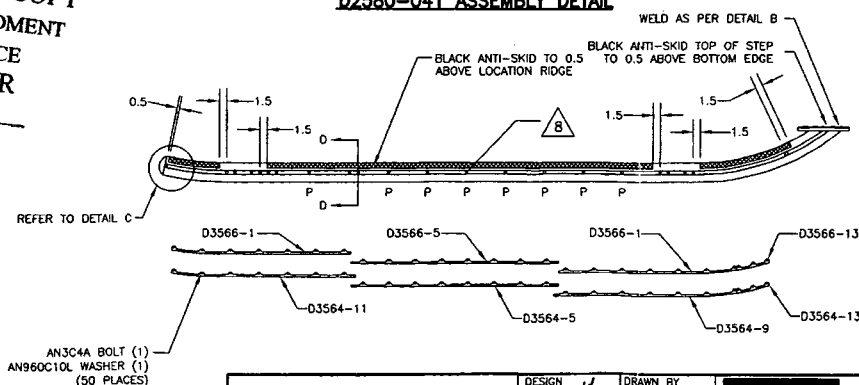
D2580-1 DRILLING DETAIL



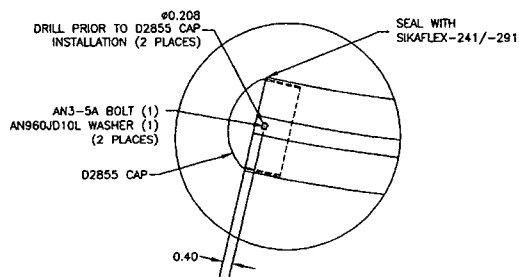
D2580-1 BENDING AND CUTTING DETAIL



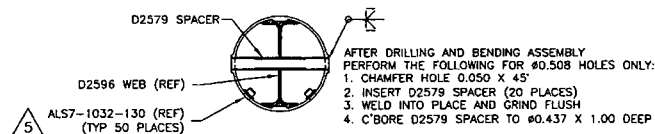
D2580-041 ASSEMBLY DETAIL



DETAIL C
SCALE 5:24



SECTION D-D
SCALE 5:24



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NO. 65480

D2580-041 NOTES

- i) FINISH: ACID ETCH, ALODINE PER DART QSI 005 4.1 PRIOR TO INSERTING D2596 WEB
POWDER COAT ASSEMBLY GLOSS WHITE (REF. 4.3.5.1) PER DART QSI 005 4.3
BLACK ANTI-SKID PAINT AS INDICATED PER DART QSI 005 4.4

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DESIGN	DRAWN BY	DART	DART AEROSPACE LTD. WARRICKSBURY, OXFORD, ENGLAND
CHECKED	APPROVED	DRAWING NO.	REV. 0
DATE		D2580	SHEET 2 OF 3
07.02.27		TITLE	SCALE
		205 SKIDTUBE ASSEMBLY	1:24

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

RELEASED
07-06-28

Diagram illustrating the underside of the D2576-3 step, showing the location of the grinding flush and the location ridge on the underside of the D2576.

Labels in the diagram include:

- GRIND FLUSH (4 PLACES)
- GRIND FLUSH
- D2576-3 STEP
- LOCATION RIDGE ON UNDERSIDE OF D2576
- $\frac{1}{4}$

37.50
DISTANCE TO AFT END
OF D2596 WEB
37.50
3
7
1.750
1.750
#0.508 (TYP.)
(40 PLACES)
REFER TO DETAIL E
REFER TO DETAIL A
8.750
17.375
26.000
34.188
57.313 (REF)
7 EQUAL SPACES
8.188 PITCH
38.0
91.500
190.0
(D2500-1)

Technical drawing of a horizontal curve showing dimensions and callouts. The drawing includes a horizontal line representing the curve, with various dimensions and callouts. Key dimensions include: 5.985, 1.4, 5.338 (REF), 51.340, 39.580, 5.915, 3.630 (REF), 20.0, 1.0, 1.0, 13.4, 32.0 ± 1.0, and 0.640. Callouts include '4' and '0.508 (8 PLACES)'. The drawing is labeled 'MAKE FROM D2360-1 DRILLING DETAIL'.

D3560-049 ASSEMBLY DETAIL

WELD AS PER DETAIL F

BLACK ANTI-SKID TO 0.5 ABOVE LOCATION RIDGE

BLACK ANTI-SKID TOP OF STEP TO 0.5 ABOVE BOTTOM EDGE

NO C'BORE NO PLUG

REFER TO DETAIL G

H

P P P P P P P P

8

D3566-1

D3566-5

D3566-1

D3566-13

D3564-11

D3564-5

D3564-9

D3564-13

AN3C4A BOLT (1)

AN56OC1OL WASHER (1)

(SO PLACES)

DESIGN	DRAWN BY
--------	----------

DRILL PRIOR TO D2855 CAP
INSTALLATION (2 PLACES)

0.208

SEAL WITH
SIKAFLEX-241/-291

AN3-5A BOLT (1)
AN960JD10L WASHER (1)
(2 PLACES)

D2855 CAP

SEE NOTE ii)

0.40

D2579 SPACER

D2596 WEB (REF)

ALS7-1032-130 (REF)
(TYP 50 PLACES)

AFTER PERFORM

1. CHA
2. INS
3. WEL
4. C'B

AFTER DRILLING AND BENDING ASSEMBLY
PERFORM THE FOLLOWING FOR Ø0.508 HOLES ONLY:

1. CHAMFER HOLE 0.050 X 45°
2. INSERT D2579 SPACER (20 PLACES)
3. WELD INTO PLACE AND GRIND FLUSH
4. C'BORE D2579 SPACER TO Ø0.437 X 1.00 DEEP

i) FINISH: ACID ETCH, ALODINE PER DART QSI 005 4.1 PRIOR TO INSERTING D2596 WEB
POWDER COAT ENTIRE ASSEMBLY GREEN (REF. 4.3.5.8) PER DART QSI 005 4.3
BLACK ANTI-SKID PAINT AS INDICATED PER DART QSI 005 4.4

ii) IT IS ACCEPTABLE TO GRIND A RELIEF IN THE D2855 AFT CAP TO PREVENT INTERFERENCE
WITH THE SPACER AT THIS LOCATION

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DESIGN	<i>RH</i>
CHECKED	<i>[Signature]</i>
DATE	07.02.27

DRAWN BY	Rb
APPROVED	+

DART
DRAWING NO. D2580
TITLE 205 SKIDTUE

DART AEROSPACE LTD.
HAMMERSBURY, ONTARIO, CANADA

REV. D
SHEET 3 OF 3
SCALE
1:24

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DRAWING NO. D2580	TITLE 205 SKIDTUBE ASSEMBLY	REV. D	DART AEROSPACE LTD ENGINEERING ORDER		D.E.O. NO. D2580-D-1	SHEET NO. SHEET 1 OF 1	SCALE NTS
DRAWN <i>UP</i>	CHECKED <i>L</i>	MFG. APPR. <i>B</i>	APPROVED <i>MP</i>		DE APPR. <i>H</i>		
DATE 10.09.22	DATE 10.11.04	DATE 10.11.04	DATE 10/11/04		DATE 10.11.04		

PURPOSE:

CHANGE ALL WELDED CROSSBOLT SPACERS TO SWAGED SPACERS

CHANGE:

PARTS LIST IS AMENDED AS FOLLOWS:

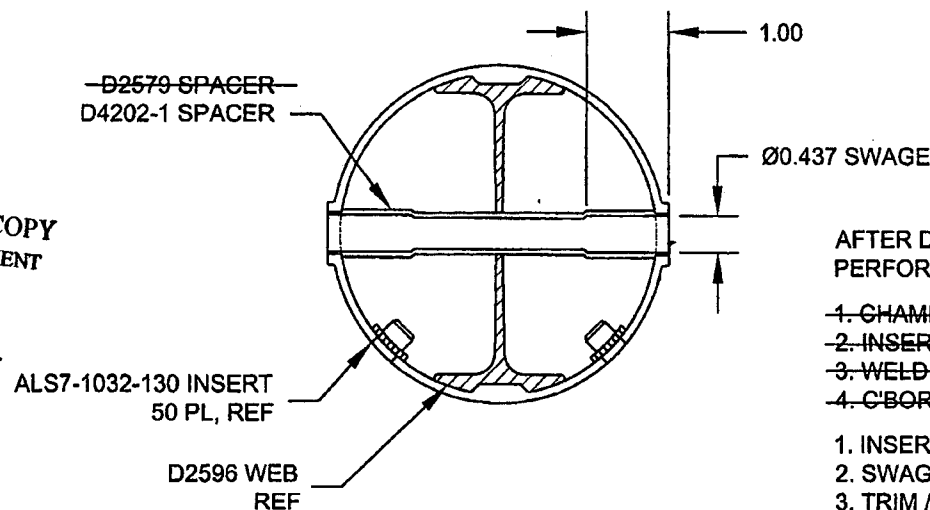
WAS

QTY	QTY	PART NUMBER	DESCRIPTION
-041	-045		
20	24	D2579	CROSS BOLT SPACER

IS

20	24	D4202-1	SPACER
----	----	---------	--------

SECTION D-D & SECTION H-H ARE AMENDED AS FOLLOWS:



RELEASED
2010-11-18
MP

AFTER DRILLING AND BENDING ASSEMBLY
PERFORM THE FOLLOWING FOR Ø0.508 HOLES ONLY:

1. CHAMFER HOLE 0.050 X 45°
2. INSERT D2579 SPACER (20 PLACES)
3. WELD INTO PLACE AND GRIND FLUSH
4. C-BORE D2579 SPACER TO Ø0.437 X 1.00 DEEP
1. INSERT D4202-1 SPACER, 20 PL (-041) OR 24 PL (-045)
2. SWAGE TO Ø0.437 X 1.00 DEEP PER QSI 002
3. TRIM / GRIND FLUSH PER QSI 002

SECTION D-D
NOT TO SCALE

SECTION H-H
NOT TO SCALE

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W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries